

Work Order ID 57414

Page 1

April 6, 2010 3:10:23 PM

Item ID: D4054-009

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 4/06/10 Start Qty: 6.00



Cust Item ID:

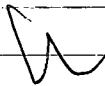
Required Date: 4/12/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4054	A

100



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Bend tube as per Dwg D4054

=7 min 10/04/08

Install sleeves and nuts

Flare ends as per Dwg D4054.

110



QC5- Inspect part completeness to step on W/O

0.00

S wlo4109

QC

Memo

0.00

Quality Control

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 4/06/10 Start Qty: 6.00



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Required Date: 4/12/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Packaging

Packaging

Identify as per dwg & Stock Location: 110

0.00

Re/4/13 (6)

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/14 AJ

MF

10-4-14

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Picklist Print

Page 1

April 6, 2010 3:10:22 PM

Work Order ID: 57414



Parent Item: D4054-009



Parent Item Name: Tube Assembly

Start Date: 4/06/10

Required Date: 4/12/10

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN818-8D Purchased No 100 Each 39.0000 6.0000

Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST331 39
113795 ✓ 39

m-h

10/04/07

M6061T6T0.500W.049 Purchased No 100 f 66.5830 3.4737

6061-T6 RD Tube .500 x.049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT014 66.583
111028 36
111944 ✓ 30.583

m-h

3-4737 10/04/07

MS20819-8D Purchased No 100 Each 70.0000 6.0000

Sleeve

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST323 70
112612 ✓ 20
113795 50

6X m-h
10/04/07

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ITEM NO.	QTY	P/N	DESCRIPTION
1	X	D4054-001	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT

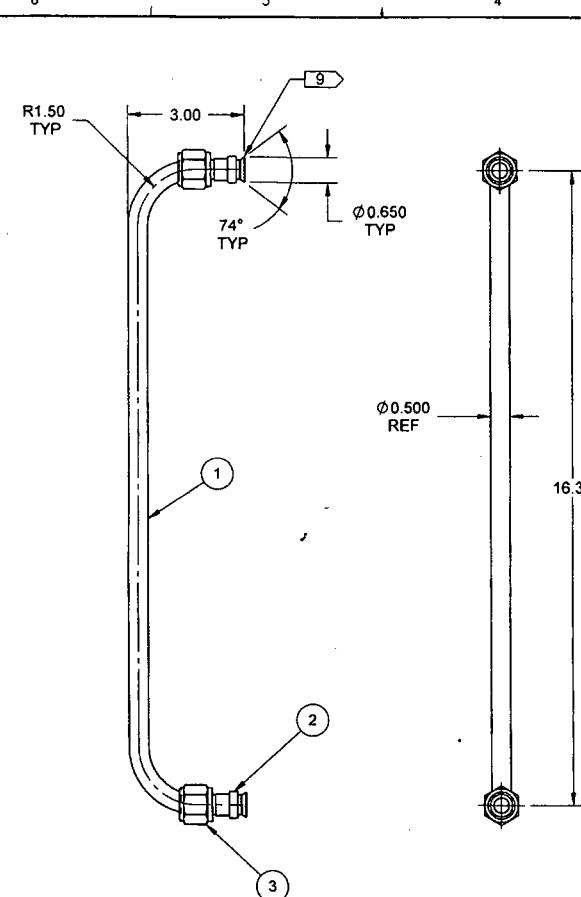
W.O. 57444

RELEASED
R 2010-01-14
M

D4054-001 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED



A	NEW ISSUE	RF	09.12.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO. REV. A	
MFG. APPR.	<i>BC</i>	D4054 SHEET 1 OF 3	
APPROVED	<i>AD</i>	TITLE SCALE	
DE APPR.	<i>AD</i>	TUBE ASSEMBLIES NTS	
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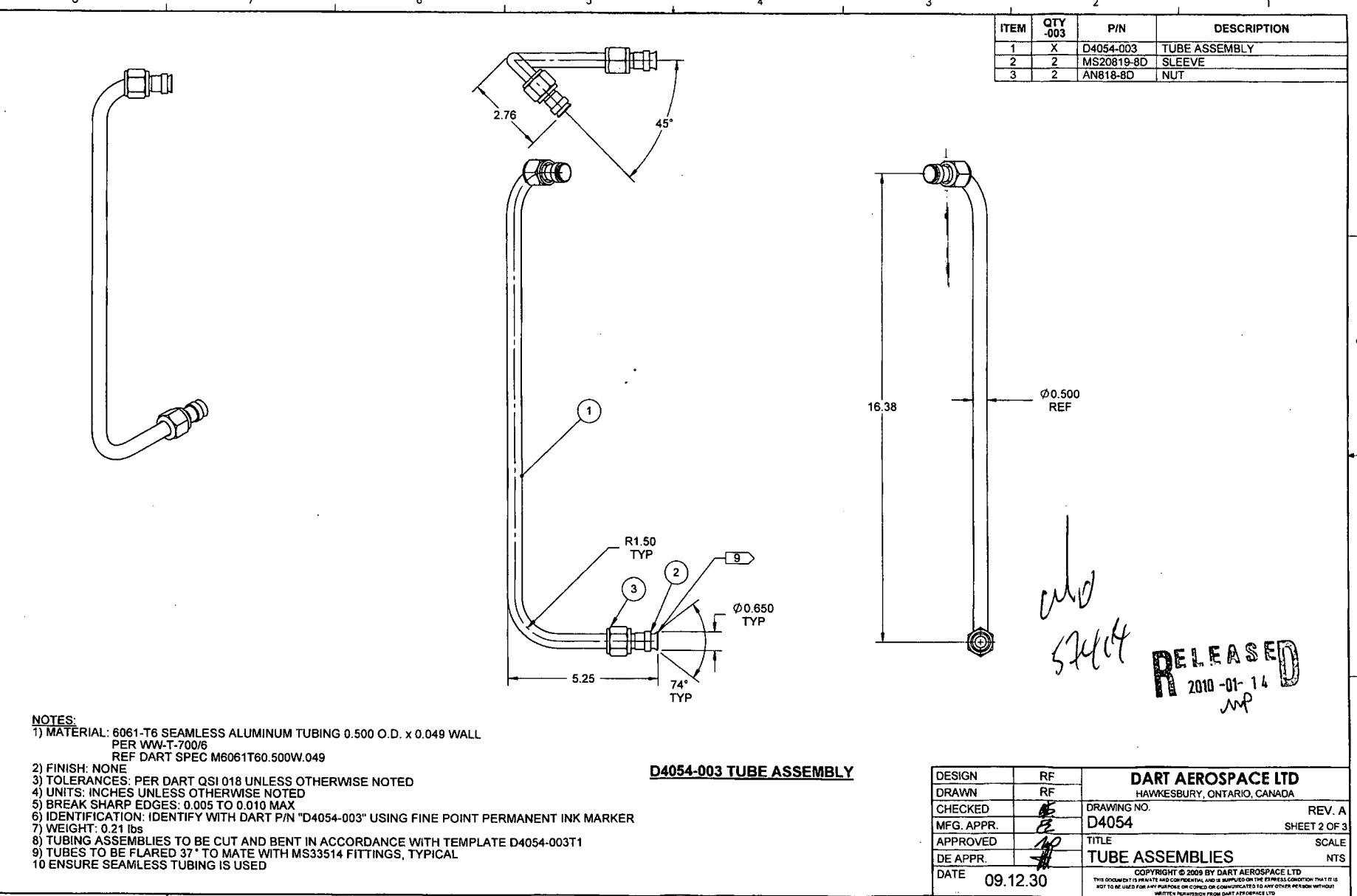
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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>EZ</i>	DRAWING NO.	
MFG. APPR.	<i>EZ</i>	REV. A	
APPROVED	<i>MP</i>	D4054	
DE APPR.	<i>MP</i>	SHEET 2 OF 3	
DATE	09.12.30	TITLE	TUBE ASSEMBLIES
		SCALE	NTS

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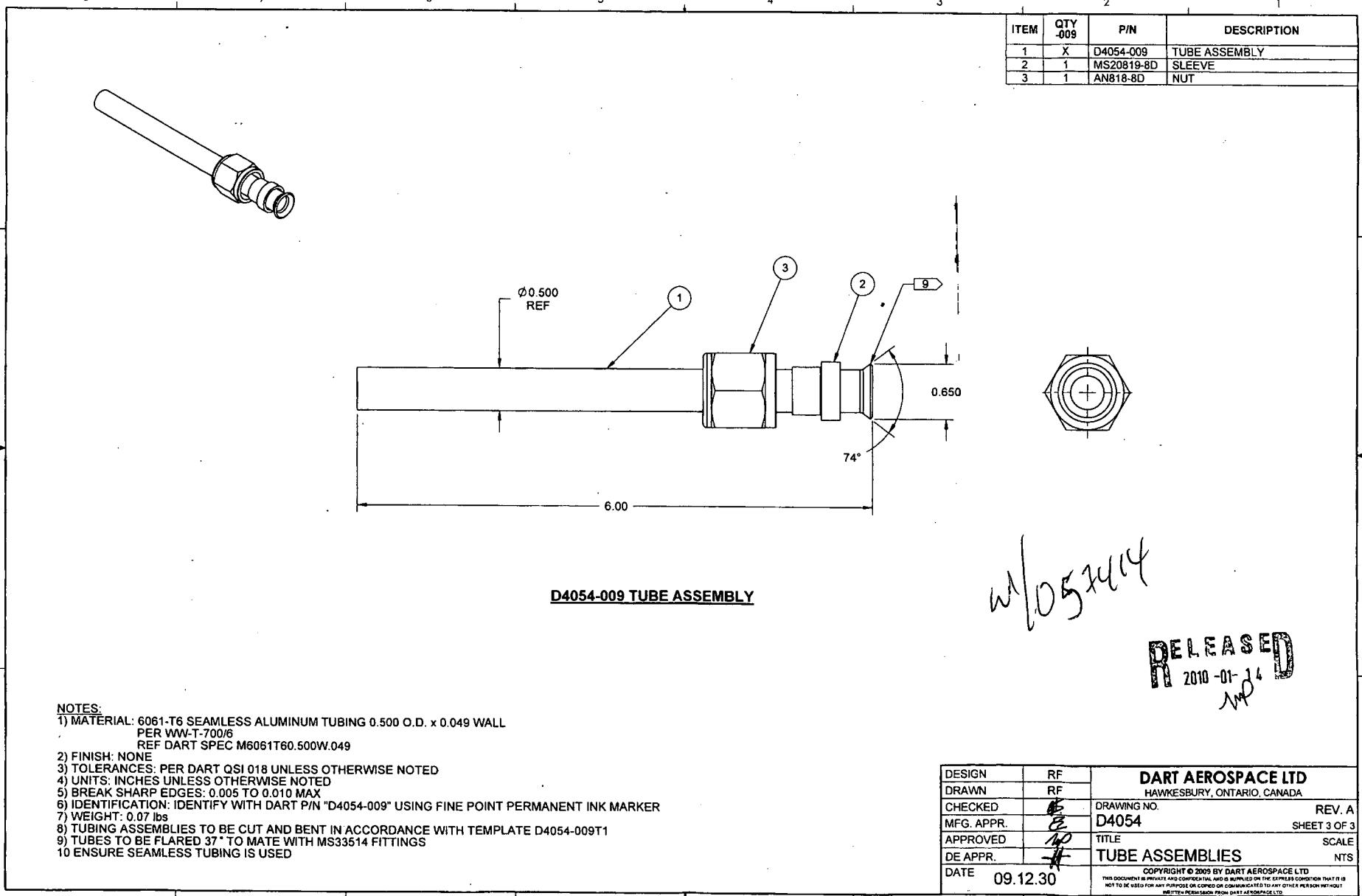
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D4054-009 TUBE ASSEMBLY

NOTES:

1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.07 lbs

8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1

9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS

10) ENSURE SEAMLESS TUBING IS USED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKSBURY, ONTARIO, CANADA	
CHECKED	<u>AB</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>B3</u>	D4054	SHEET 3 OF 3
APPROVED	<u>MP</u>	TITLE	SCALE
DE APPR.	<u>-</u>	TUBE ASSEMBLIES	
DATE	09.12.30	NTS	

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